

Date: Tuesday, 10/2/2007 3:27:54 PM
User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SKIDTUBE INSERT
Job Number	: 34994		
Estimate Number	: 12553		
P.O. Number	:	Part Number	: D3510041
This Issue	: 10/2/2007 S.O. No. :	Drawing Number	: D3510 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11 Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	:	Material	:
Written By	: <u>10/10/02</u>	Due Date	: 10/9/2007 Qty: 2 Um: Each
Checked & Approved By	:		
Comment	: Est Rev:A New Issue 06-10-12 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6046065-606176T3.500XW375	135 SKIDTUBE EXTENSION
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Comment: Qty.: 0.5000 Each(s)/Unit Total: 2.0000 Each(s)
135 SKIDTUBE EXTENSION
Batch: M131448

2.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
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Comment: MORI SEIKI CNC LATHE LARGE
Turn as per Dwg D3510 & Folio FA652
Ensure that DT8877A Plug fits in tube.

1 J.L. 07/10/04 (2)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

1 J.L. 07/10/04 (2)

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
1-Machine as per Folio FA652 and Dwg D3510

2-Drill Manually using DT8877B as per Dwg D3510

3-Deburr

N/A

08/09/20

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

08/09/20 (2)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE INSERT

Job Number: 34994

Part Number: D3510041

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 QC8 SECOND CHECK



Comment: SECOND CHECK

7.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
1-Chemical Conversion Coat as per QSI 005 4.1

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0 ~~NAS1330C3K8246~~ INSERT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)
INSERT
Batch: 1110511

10.0 ~~NAS1330C3K8316~~ INSERT



Comment: Qty.: 6.0000 Each(s)/Unit Total: 24.0000 Each(s)
INSERT
Batch: 1110768

11.0 ~~NAS1330C3K8271~~ INSERT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)
INSERT
Batch: 116989

12.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Install inserts as per Dwg D3510

13.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

1- Drill Remaining hole using DT8877B
2- Counter Bore Wear plate holes as per Dwg D3510.
6.2 QCS - 8/12/12 (2)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
20.09.29	6-1	As shown.	<i>[Signature]</i>	20.09.29			<i>[Signature]</i> 21/12/12

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: D3510041

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST 139 F

SS 09/05/25 (X2)
09/05/29

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-05-29

DART AEROSPACE LTD		Work Order: 34994
Description: SKIDTUBE INSERT		Part Number: D3510041
Inspection Dwg: D3510 Rev: A		Page 1 of 1

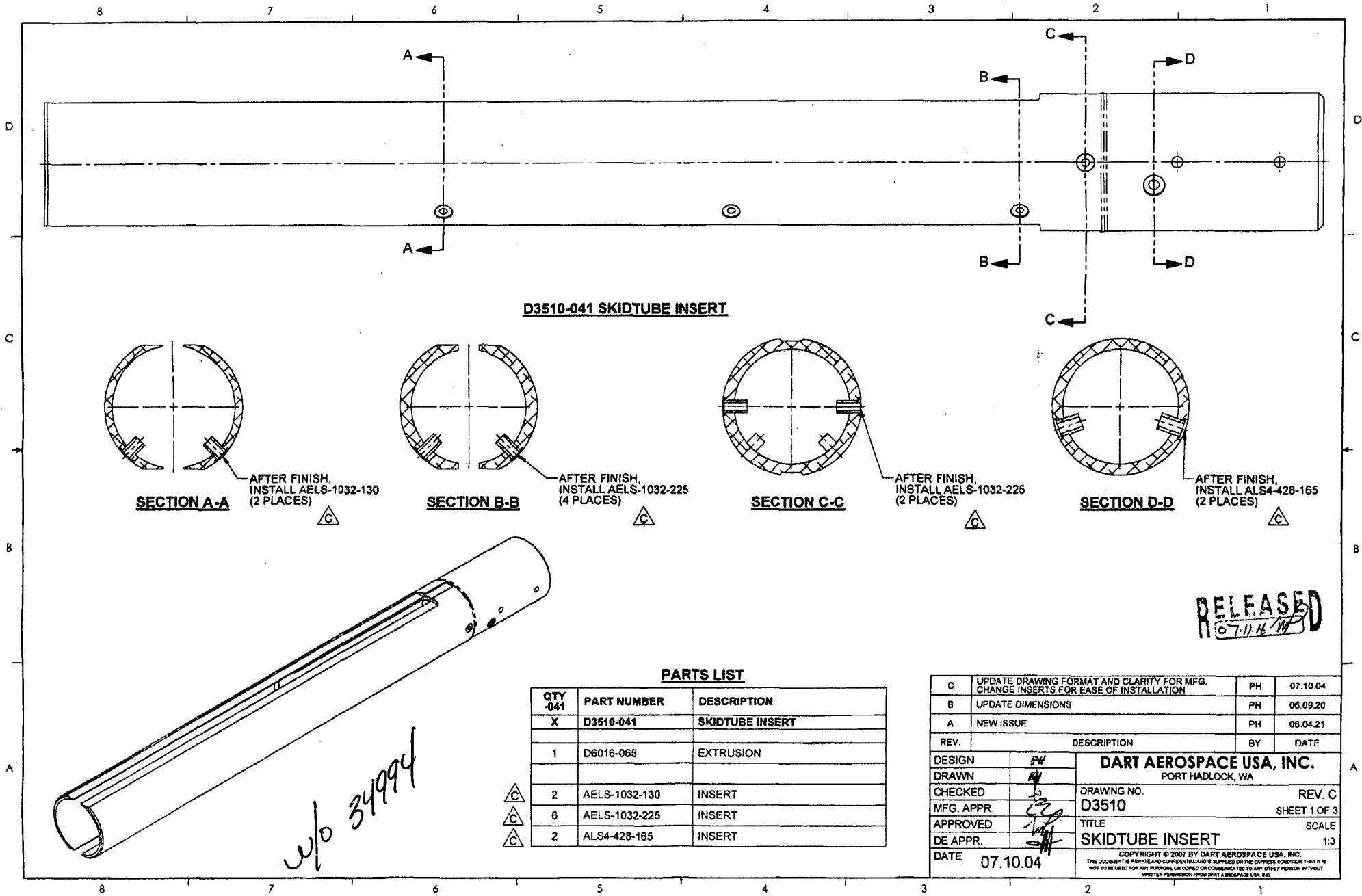
FIRST ARTICLE INSPECTION CHECKLIST

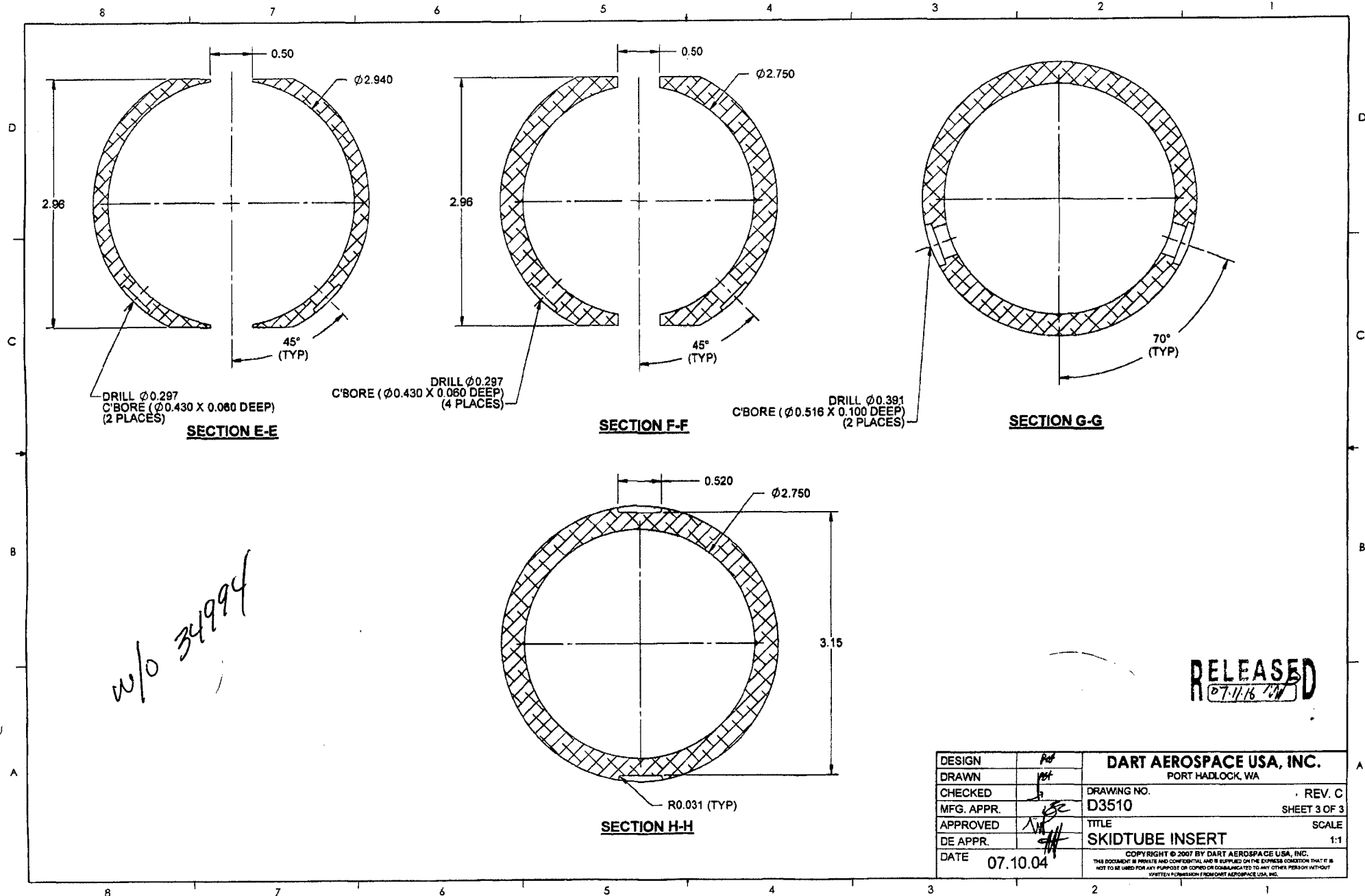
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.300	+ .010	3.300	✓			
2.940	+ .010	2.941	✓			
2.750	+ .010	2.754	✓			
1.25X.066	+ .010	1.25X.066	✓			
15.00	+ .030	15.00	✓			
.063X45°	+ .010	.06X45°	✓			
.125X45°	+ .010	.125X45°	✓			
5.270	+ .010	5.265	✓			
3.265	+ .010	3.261	✓			
30.5	+ .030	30.510	✓			
9.515	+/- .010	9.515	✓			
6.875	+/- .010	6.875	✓			
13.750	+/- .010	13.750	✓			
1.600	+/- .010	1.600	✓			
2.165	+/- .010	2.165	✓			
6.735	+/- .010	6.735	✓			
2.981	+/- .010	2.981	✓			
2.434	+/- .010	2.434	✓			
1.036	+/- .010	1.036	✓			
.266	+/- .001	.266	✓			
.391 X	+/- .010	.393	✓			
.516 X	+/- .010	.520	✓			
.100	+/- .010	.107	✓			

Measured by: J.L.	Audited by: [Signature]	Prototype Approval: [Signature]
Date: 07/10/05	Date: 07/10/05	Date: [Signature]

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	





RELEASED
07-11-16

DESIGN	POB	DART AEROSPACE USA, INC.	
DRAWN	POB	PORT HADLOCK, WA	
CHECKED	J	DRAWING NO.	REV. C
MFG. APPR.	JSC	D3510	SHEET 3 OF 3
APPROVED	NH	TITLE	SCALE
DE APPR.	SH	SKIDTUBE INSERT	1:1
DATE	07.10.04	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	